



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3690-1
Job Sheet 183456



Part No: D3690-1

Job Qty: 1 ea

Part Name: Glareshield



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev A New Issue 08/04/28 DL verified by:DD IPP Rev:B 08-07-14 revB as per dwg DD
verified by:ec IPP Rev:C 08-10-07 revC as per dwg DD verified by:EC Ipp Rev. D Add Step 115 Dry Material
10/04/21 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	1 pcs		10/12/18	0.00	0.00	Purchasing		OCT 23 2018
140	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging2		OCT 23 2018
150	QC	1 pcs		10/12/18	0.00	0.00	QC6		OCT 23 2018
170	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging3-1		OCT 30 2018
180	QC21-SA	1 Ea		10/12/18	0.00	0.00	QC21		OCT 30 2018

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
Descriptions: 150 - QC6- All purchased or subcontracted products
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

PO 041067 < 1 Rho Sept 19, 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3690-1P	Glareshield	1 pcs (1 ea)	110-Purchasing	5120697
MLEXS.093-F6006-02	GE Plastics Lexan Sheet (Black)	26.3250 sf (26.325 ea)	110-Purchasing	5120697

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D3690-1P	1	0	0
	MLEXS.093-F6006-02	26	1,002	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ould not be found.

Plex 9/18/18 12:43 PM Dart.lajeunesse.marie

Container No: S120700



Part: D3690-1

Job No: 183456

Serial No/Batch: S120700

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/23/18

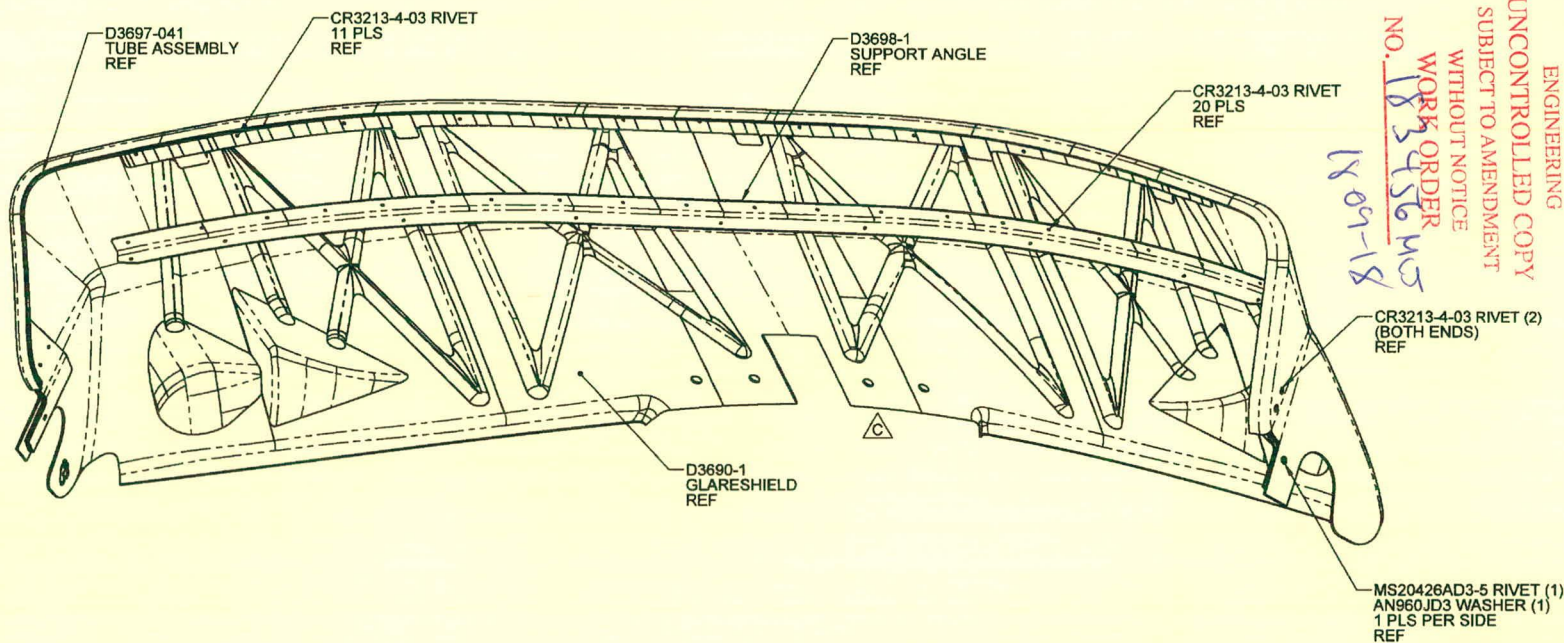
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 18345645
1809-18

RELEASED
28-09-18

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
2	AN960JD3	WASHER (OR NAS1149DN332J)
2	MS20426AD3-5	RIVET
35	CR3213-4-03	RIVET

D3690-041 GLARESHIELD ASSEMBLY

C	SHEET 1 PL MS20426AD3-5 RIVET WAS MS20426AD3-4 CR3213-4-03 RIVET WAS MS20470AD3-4 WASHER QTY WAS 6 (VIEWS UPDATED ACCORDINGLY). RIVETS ON SHEET 1 CHANGED TO REF QTY. RIVETS ON SHEET 2 CHANGED TO "HARD" CALLOUTS. SHADING REMOVED FROM ALL VIEWS FOR CLARITY.	AJS	08.09.02
B	ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A, 8 & C, 5; ADD MIN THICKNESS. SHEET 3 ZONE A, 8	RF	08.06.24
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D3690 REV. C TITLE GLARESHIELD ASSEMBLY SCALE NTS	
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

△ C
TRANSFER DRILL Ø0.128
FROM D3698-1 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 20 PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

D3690-1
GLARESHIELD
REF

TRANSFER DRILL Ø0.098
FROM D3697-041 TO D3690-1
INSTALL
MS20426AD3-5 RIVET
AN960JD3 WASHER (ON GLARESHIELD
OUTSIDE SURFACE)
1 PER SIDE

TRANSFER DRILL Ø0.128
FROM D3697-041 TO D3690-1
INSTALL
CR3213-4-03 RIVET 2
BOTH ENDS △ C

1
D3697-041
TUBE ASSEMBLY
REF

TRANSFER DRILL Ø0.144
AT THIS LOCATION
FROM D3697-041 TO D3690-1
(NO HARDWARE INSTALLED)

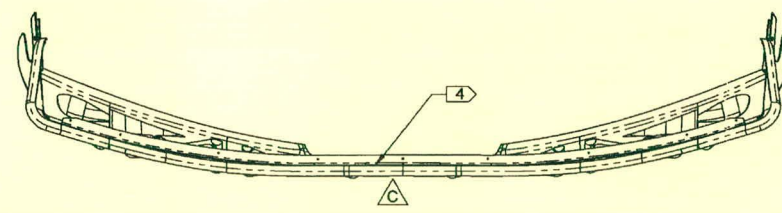
1
D3698-1
SUPPORT ANGLE
REF

EQUAL DIMENSION
AT BOTH ENDS

TRANSFER DRILL Ø0.128
FROM D3697-041 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 11PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE △ C

0.14
REF

SECTION A-A



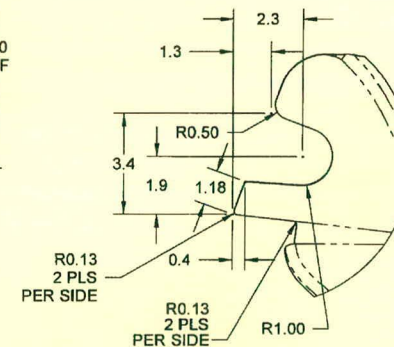
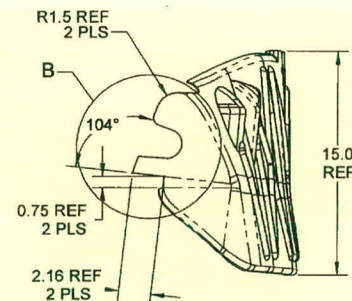
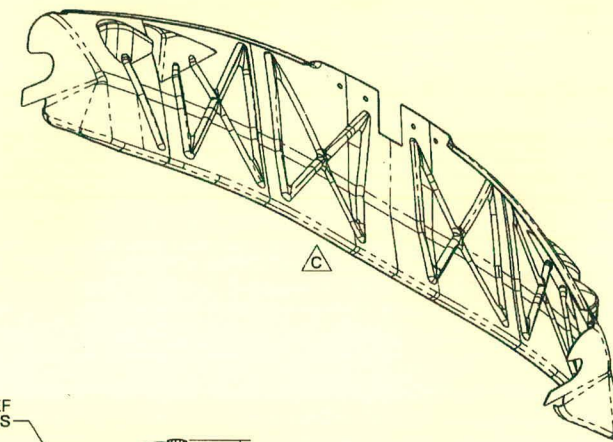
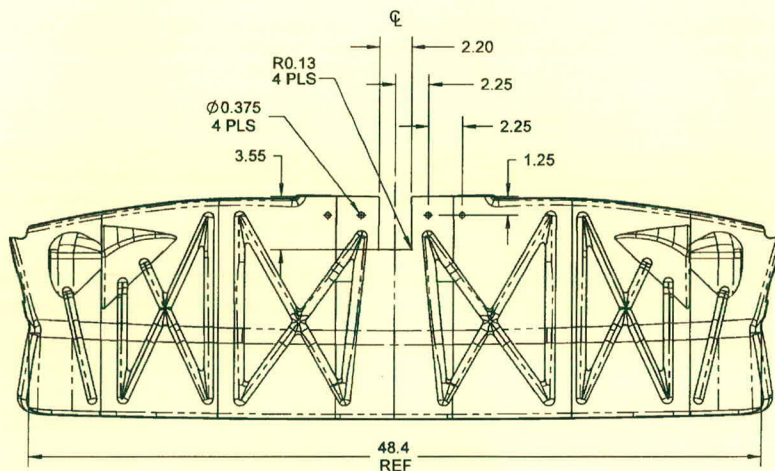
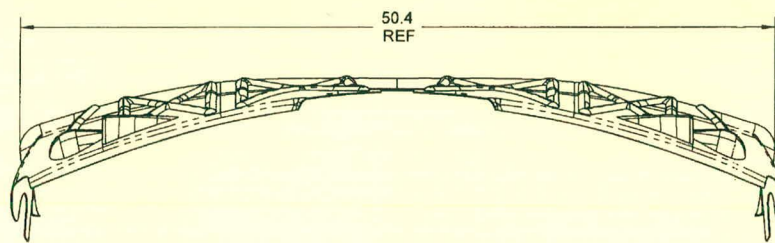
D3690-041 GLARESHIELD ASSEMBLY

- NOTES:
- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
 - 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50 PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
 - 5) WEIGHT: 2.98 lbs
 - 6) MASK HATCHED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING

RELEASED
08-09-11

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3690	REV. C
MFG. APPR.	RF	SHEET 2 OF 3	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GLARESHIELD ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D3690-1 GLARESHIELD

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040

RELEASED
08-09-02

DETAIL B
SCALE 2X
THIS VIEW FOR REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041067**

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO041067
PO Date: 9/19/18
Due Date: 10/10/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183477	D4634-1P			Fwd, Center Ceiling Panel : Various STC's As Per DWG D4634 REV. G	Firmed	-	10/10/18	2 pcs	0 pcs	2 pcs	\$180.00/pcs	\$360.00
2	183456	D3690-1P			Glareshield : Various STC's As Per Dwg D3690 Rev. C	Firmed	-	10/10/18	1 pcs	0 pcs	1 pcs	\$526.00/pcs	\$526.00

Grand Total: \$886.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 9/19/18 11:10 AM dart.Lussier.Patrick

DAS
38
9-89

2000
51
1000



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Packing Slip

Shipment Number: 31820
Shipment Date: 10/22/2018
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: DALE BATES
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: PATRICK LUSSIER
O

Purchase Order
41067 ✓

Sales Order
SO-025500

Incoterms
EX WORKS

Payment Method
COL

Carrier Account #
151793240

Ship Via
FEDERAL EXPRESS - Ground

Tracking Number
773529434875

Item Number
Revision

D3690-1P - Rev.: C ✓

Description

GLARESHIELD ASSEMBLY
AS PER DWG D3690 REV C

Quantity UOM
Shipped

1 ✓ EA

DAS
38
9-89

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD

P.O. #

41067 ✓

SO #

025500

Part #	D3690-1P ✓	Qty.	1 ✓	Batch #	-002
Description	GLARESHIELD ASSEMBLY	Material usage	1 SHEET	Lot#	DART0119 0007444100
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AS

(Approved QA Signatory)

Date:

OCT. 19, 2018

C OF C #

088

Page: 1 of 1

DAC
38
9-89

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

